

Date: Monday, 2/27/2006 4:22:11 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 25998	Part Number	: D2573		
Estimate Number	: 10533	Drawing Number	: D2573 REV E		
P.O. Number	: N/A	Project Number	: N/A		
This Issue	: 2/27/2006	S.O. No.	: N/A	Drawing Revision	: E
Prsht Rev.	: NC	Type	MACHINED PARTS	Material	: N/A
First Issue	: N/A			Due Date	: 3/15/2006
Previous Run	: 25861			Qty:	8 Um: Each
Written By	<u>See comment below</u>				
Checked & Approved By	<u>KJ 06.02.28</u>				
Comment	Est: I As Per RevE 06-01-27 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <u>B249893</u>	(B)
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>25998</u> Double check by: <u>M8</u>  1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	J.G 06/03/11 8
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	<u>HAAS</u> J.G 06/03/11 8
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.G 06/03/11 8

REFERENCE ONLY

Date: Monday, 2/27/2006 4:22:11 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 25998

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 06.03.13 (8)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FC 06 03 13 (8)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/03/14 (8)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

W 06 03 15 (8)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Y80

1/4/3/16 (8)

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(8) 06/03/16

Job Completion



U 06/03/16

DART AEROSPACE LTD	Work Order:	25998
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.747	1.747	1.747	1.747		
C	3.495	3.505		3.500	3.501	3.500	3.499		
D	1.745	1.755		1.747	1.747	1.747	1.747		
E	7.990	8.010		8.002	8.003	8.002	8.002		
F	0.490	0.510		0.501	0.501	0.500	0.500		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.499	0.498	0.498	0.497		
J	1.174	1.184		1.178	1.177	1.177	1.177		
K	0.558	0.578		0.569	0.568	0.569	0.569		
L	1.174	1.184		1.178	1.178	1.177	1.177		
M	1.365	1.375		1.369	1.369	1.370	1.371		
N	2.495	2.505		2.500	2.499	2.498	2.499		
O	4.119	4.129		4.122	4.122	4.122	4.121		
P	0.115	0.135		0.128	0.127	0.129	0.130		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.244	0.248	0.247	0.246		
S	0.115	0.135		0.130	0.130	0.130	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.222	3.221	3.220	3.221		
V	0.230	0.250		0.234	0.239	0.239	0.239		
W	0.115	0.135		0.127	0.128	0.127	0.127		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.362	0.361	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.629	0.628	0.627	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.246	0.245	0.245		
AE	1.500	1.520		1.515	1.514	1.513	1.514		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.249	0.248	0.249		
AI	2.000	2.020		2.005	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.036		
Accept/Reject									

Measured by:	J.G.
Date:	06/03/12

Audited by:	SD
Date:	06/03/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	25998
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

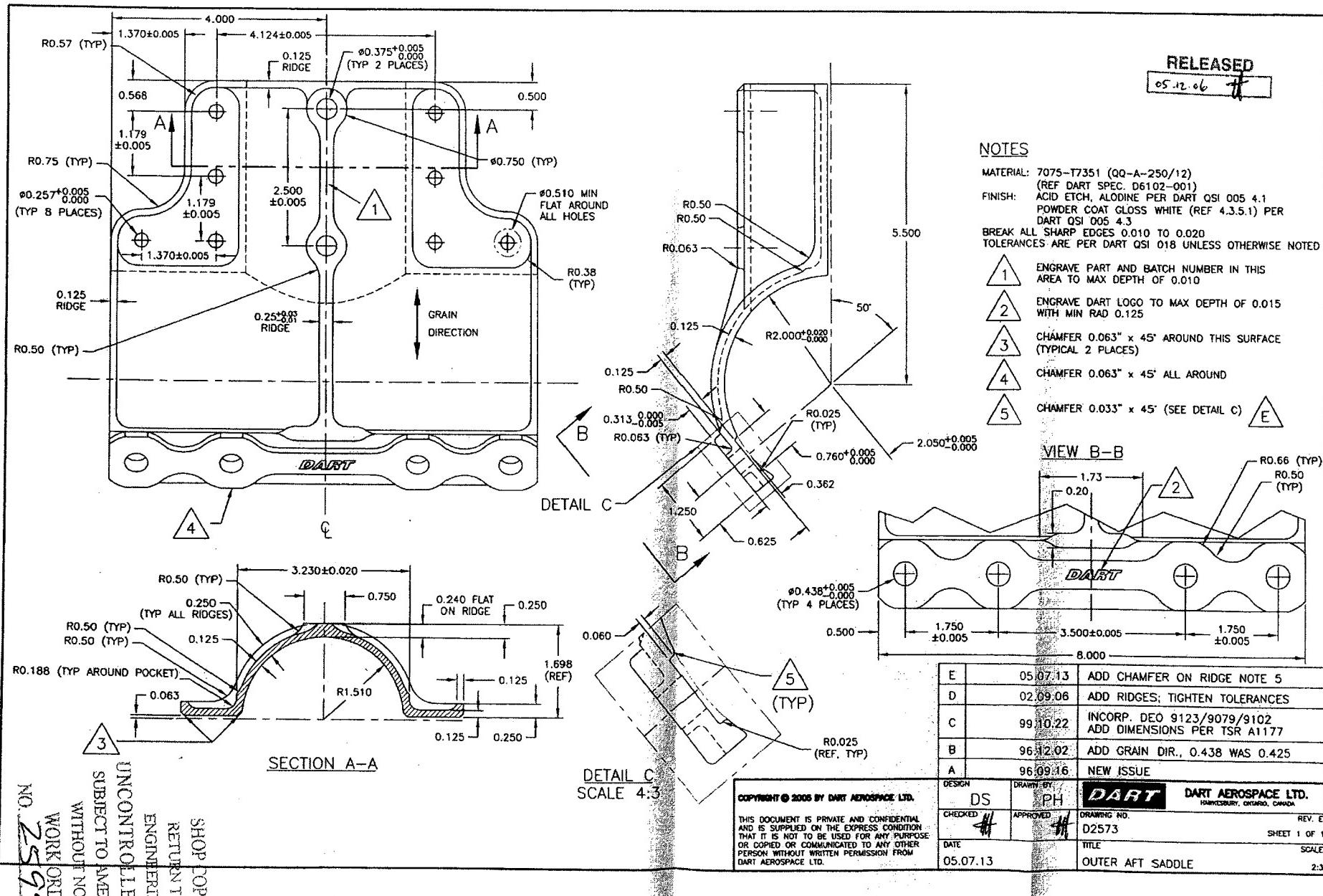
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.747	1.747	1.747	1.748		
C	3.495	3.505		3.498	3.498	3.498	3.498		
D	1.745	1.755		1.747	1.747	1.747	1.747		
E	7.990	8.010		8.003	8.003	8.003	8.003		
F	0.490	0.510		0.501	0.500	0.499	0.499		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.499	0.499	0.498	0.498		
J	1.174	1.184		1.177	1.177	1.177	1.178		
K	0.558	0.578		0.568	0.569	0.569	0.568		
L	1.174	1.184		1.177	1.177	1.176	1.176		
M	1.365	1.375		1.371	1.371	1.372	1.371		
N	2.495	2.505		2.499	2.499	2.498	2.498		
O	4.119	4.129		4.120	4.121	4.121	4.121		
P	0.115	0.135		0.120	0.121	0.122	0.122		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.245	0.245	0.245	0.246		
S	0.115	0.135		0.127	0.126	0.127	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.220	3.220	3.220	3.220		
V	0.230	0.250		0.244	0.241	0.242	0.244		
W	0.115	0.135		0.125	0.127	0.127	0.127		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.765		
Z	0.352	0.372		0.362	0.362	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.628	0.628	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.241	0.242	0.242	0.242		
AE	1.500	1.520		1.512	1.513	1.513	1.513		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.250	0.249	0.249		
AI	2.000	2.020		2.002	2.003	2.003	2.002		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		

Accept/Reject

Measured by: S.G.  
Date: 06/03/13

Audited by: SA  
Date: 06.03.13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/03/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:22:11 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services		<b>Drawing Name</b>	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
<b>Job Number</b>	: 25998					
<b>Estimate Number</b>	: 10533					
<b>P.O. Number</b>	:			<b>Part Number</b>	: D2573	
<b>This Issue</b>	: 2/27/2006	<b>S.O. No.</b>	: :	<b>Drawing Number</b>	: D2573 REV E	
<b>Prsht Rev.</b>	: NC			<b>Project Number</b>	: N/A	
<b>First Issue</b>	: / /	<b>Type</b>	: MACHINED PARTS	<b>Drawing Revision</b>	: E	
<b>Previous Run</b>	: 25861			<b>Material</b>	:	
<b>Written By</b>	:			<b>Due Date</b>	: 3/15/2006	Qty: 8 Um: Each
<b>Checked &amp; Approved By</b>	: <u>KJ 06.02.28</u>					
<b>Comment</b>	: Est: I As Per RevE 06-01-27 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <u>B249893</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>25998</u> Double check by: <u>M8</u>	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:22:11 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 25998

Part Number: D2573

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK 
<b>Comment:</b> SECOND CHECK		
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
<b>Comment:</b> HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		
7.0	POWDER COATING	POWDER COATING 
<b>Comment:</b> POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
<b>Comment:</b> INSPECT POWDER COAT		
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: _____		
10.0	DC	DOCUMENT CONTROL 
<b>Comment:</b> DOCUMENT CONTROL Inspection Level 21		

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

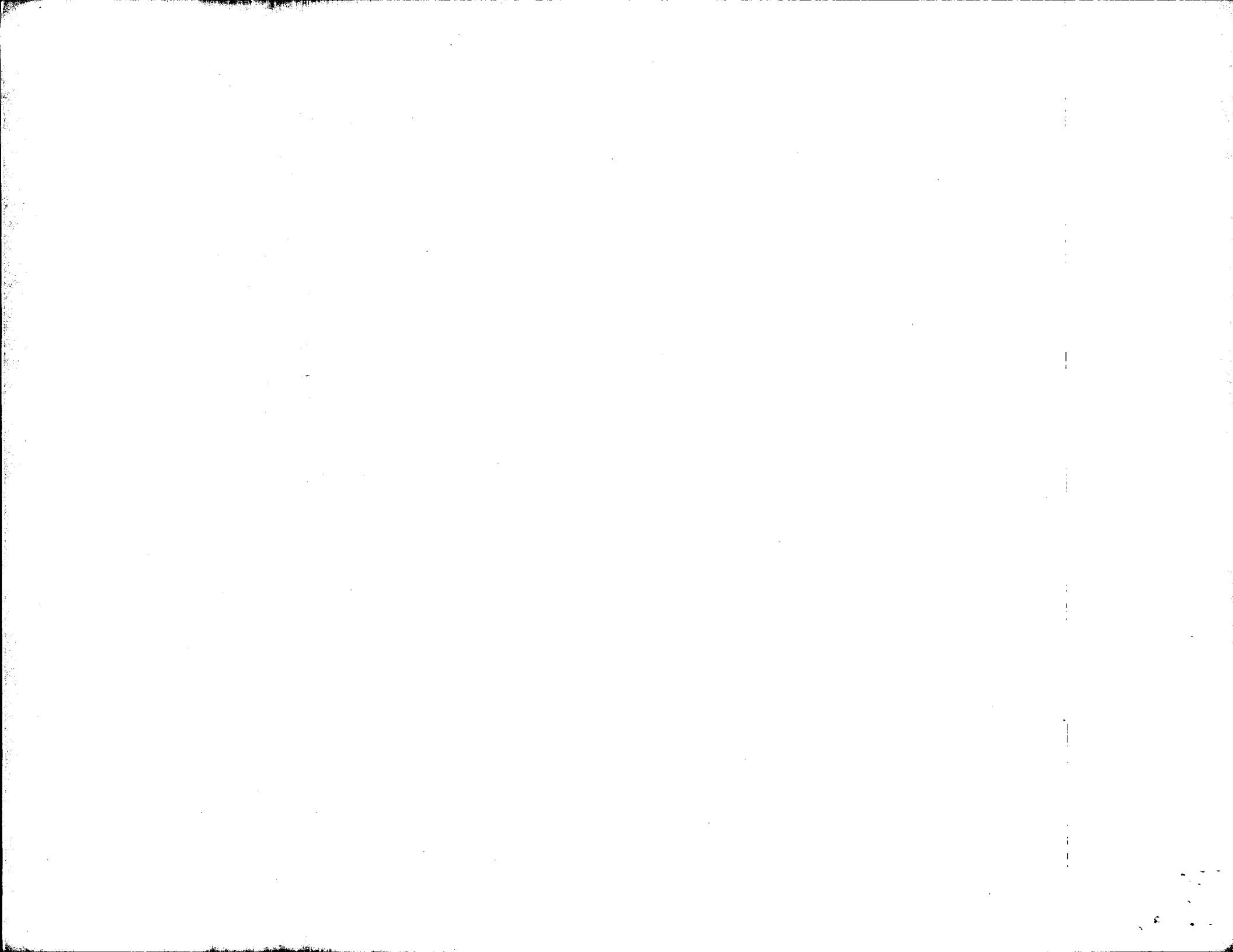
DART AEROSPACE LTD	Work Order:	25998
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755							
C	3.495	3.505							
D	1.745	1.755							
E	7.990	8.010							
F	0.490	0.510							
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510							
J	1.174	1.184							
K	0.558	0.578							
L	1.174	1.184							
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P	0.115	0.135							
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260							
S	0.115	0.135							
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250							
V	0.230	0.250							
W	0.115	0.135							
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372							
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635							
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260							
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AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260							
AI	2.000	2.020							
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:		Audited by:	
Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



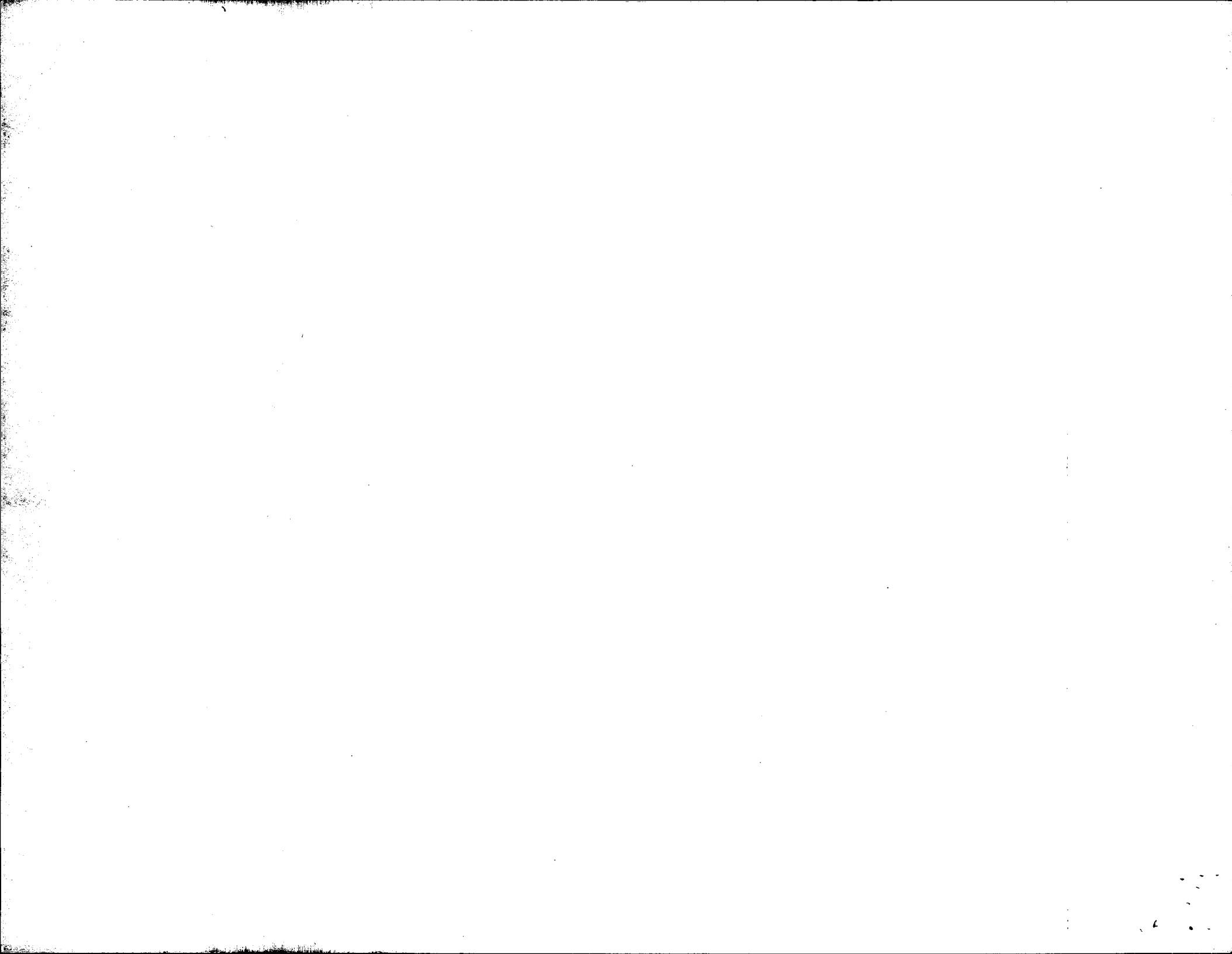
DART AEROSPACE LTD	Work Order:	25998
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

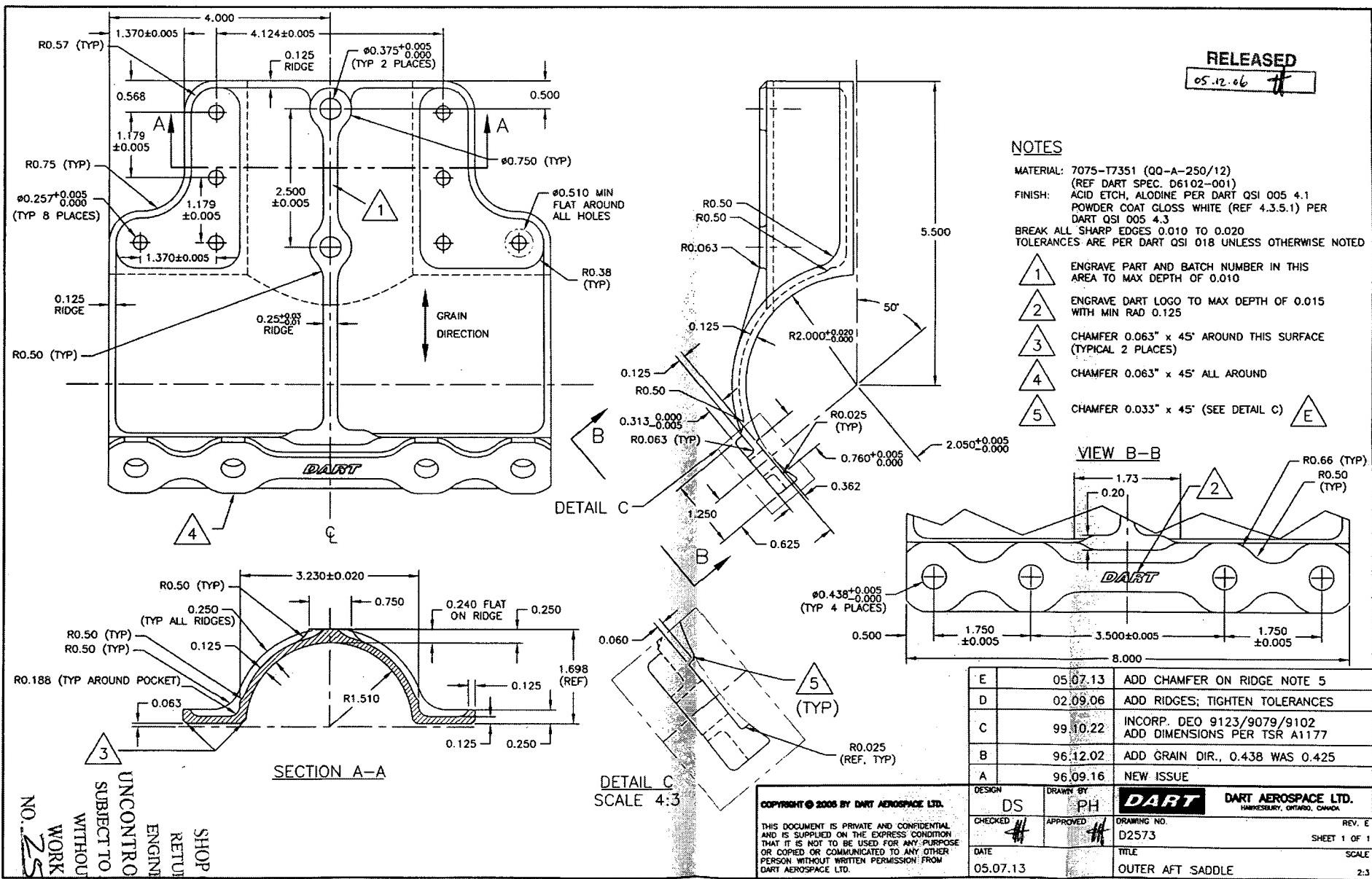
Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
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U	3.210	3.250							
V	0.230	0.250							
W	0.115	0.135							
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372							
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635							
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260							
AE	1.500	1.520							
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260							
AI	2.000	2.020							
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:		Audited by:	
Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	





UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER NO. 25998  
 ENGINEERING COPY  
 RETURN TO  
 SHOP COPY